



Aluminium Hull

www.nautix.com
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A 6 step process

1. Substrate preparation
2. Adhesion promoter : METAPOX
3. Insulation : EPOXYGARD
4. Fairing WATERTIGHT or BLUE FILLER EPOXY
5. Protection : EPOXYGARD
6. Finishing paints



STEP 1:

Substrate preparation

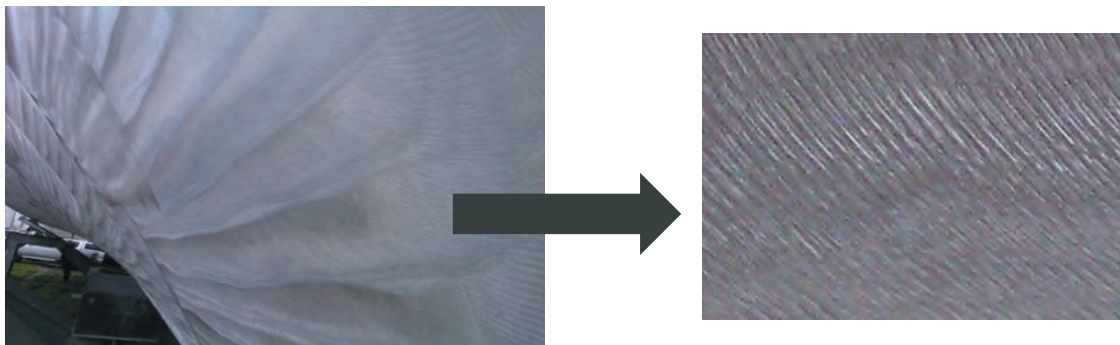
Clean the surface with soap, neutral or faintly caustic washing liquid (like diluted St Marc). Rinse with fresh water. If there is oil or fat, wash the surface with SD Nautix Degreaser.

Remove completely superficial oxidation by mechanical scouring. If possible, go on with sandblasting (medium or large grit). Otherwise use special abrasives discs as Zirconia, Ceramic or corundum (P40 or 60 grit for optimum result).

The resulting surface must be uniform, lightly dulled and rough. Do not let any shiny or smooth areas.

Rinse with fresh water, let dry thoroughly

Proceed to the painting without delay (within 1/2 day)



STEP 1:

Substrate preparation

In the case of a prolonged wait after scouring an alumina film will form on the substrate.

In that case you will have to deoxidize the surface by paper sanding (P80-120P Grit) or using SCOURING ACID with a spray before painting.

When using Scouring Acid let work for 20 minutes and rinse copiously with fresh water before applying METAPOX.

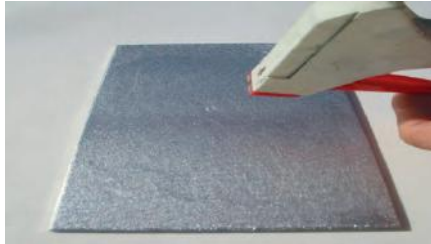
SPRAY test:

Spray water over a small area and check that the water spreads evenly.

No droplets should appear .



Roughly frosted surface



Well-frosted surface



STEP 2:

Adhesion promoter

Do not apply METAPOX if you are not sure whether you can apply a first coat of epoxy within one day.

Application in one coat by brush or roller.

Wet the surface evenly with a very thin coat
METAPOX is very liquid, do not attempt to apply thickly.

Isolate this support with an epoxy primer as soon as the Metapox is dry.

METAPOX :

This easy-to-use product has been developed to strengthen the adhesion of epoxy on aluminium. It acts by bridging between two surfaces.

Temperature	10°C	20°C	30°C
Overcoating time after metal substrate preparation		0 - 4 H	



STEP 3: Insulation

Apply a first coat of epoxy primer EPOXYGARD

Maximum recommended thickness : 130µm wet per coat

Apply with brush, roller or Airless

Avoid condensation, ensure temperature is above dew point and that hull is not colder than the room temperature.

This layer gives a hard and uniform background. It reveals hull defects before coating.

EPOXYGARD :

High performance protective coating gives long wet on wet overcoating time.



Temperature	10°C	20°C	30°C	40 C
Operating window to overcoat METAPOX with Epoxygard	2-10 H	1-8 H	1-6 H	1-5 H

STEP 4:

Fairing

Application of filler is optional : depending on importance of surface imperfection
mixing ratio 1/1 in weight & volume)

Sanding with 80-120P grit

WATERTIGHT or BLUE EPOXY FILLER :

Fast-drying WATERTIGHT filler for low thickness application (5mm) and small local repairs (density 1)

BLUE filler for high-thickness application and fairing of large surfaces (density 0,8)



Temperature	10°C	15°C	20°C	25°C
Overcoated time without sanding between EPOXYGARD and epoxy filler	Mini - Max 8h to 5 days	Mini - Max 6h to 4 days	Mini - Max 4h to 3 days	Mini - Max 3h to 2 days
Minimum time before Watertight filler sanding	9h	6h	4h	3h
Minimum time before Blue filler sanding	24h	16h	8h	5h

STEP 5: Protection

Apply 4-6 coats of Epoxygard :

Application by roller or spraygun (thinning) : 10 - 20%
Maximum Recommended thickness : 130µm wet/coat
Coverage : 7m²/L

**Respect overcoating time between layers to allow good evaporation of solvents.
DO NOT TRY TO REDUCE THE RECOMMENDED OVERCOATING TIMES.**

EPOXYGARD :

Epoxygard is an epoxy primer giving high protection against moisture.

It gives large overcoating window to aid easier application, also good resistance to abrasion



Temperature	10°C	15°C	20°C	25°C	30°C
	Mini - Max	Mini - Max	Mini - Max	Mini - Max	Mini - Max
Overcoated by itself	8h to 5 days	6h to 4 days	4h to 3 days	3h to 48h	2h to 36h
Overcoated by antifouling	8h to 30h	6h to 24h	4h to 16h	3h to 12h	2h to 8h
Drying time before sanding	24h	16h	12h	8h	6h

STEP 6: Finishing paints



Hull : Antifouling A1

Nautix A1 is a high-performance antifouling especially developed for aluminium hulls.

Apply in 2 thick coats or even a 3rd coat at the waterline

Covering 10 m²/L

For mor information check the data sheet



Topsides & Deck

Degreasing with SD Nautix then sanding

Metapox adherence promoter

Epoxygard insulation

Epoxy Filler Watertight if needed

Epoxygard protection

Nautix U2 (two-component opacifying epoxy undercoat for obtaining a plain white background)

Nautix L2 (High quality two-component finishing paint with a very high level of gloss and high resistance to U.V. rays)



This system can be coated with VA2 varnish to prevent raking, and/or mixed with Grip Additive Medium anti-slip ball.

